

Thursday, 21/08/2008 9:48:28 AM

Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FRONT RAIL, LH
Job Number	: 41541		
Estimate Number	: 13492		
P.O. Number	:	Part Number	: D37661
This Issue	: 21/08/2008 S.O. No. :	Drawing Number	: D3766 REVB
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: B
Previous Run	: 41217	Material	:
Written By	:	Due Date	: 21/08/2008
Checked & Approved By	: <u>MF 08-08-21</u>	Qty:	2 Um: Each
Comment	: Est Rev:A 08-07-21 revB as per dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6T1000W188

6061T6 RD TUBE 1.00 X .188W



Comment: Qty.: 2.9323 f(s)/Unit Total: 2.9323 f(s)

6061T6 RD TUBE 1.00 X .188W

batch: M104779SAD 08/08/21

(2)

2.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-cut tube to lenght as per dwg D3766

SAD 08/08/21

(2)

2-drill holes thru to finish size as per dwg D3766

use DT 9413

3- deburr

} FF 08/12/08

(2)

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 08/12/08

(2)

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

YSL08-12-09

(2X)

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 08/12/09

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User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRONT RAIL, LH

Job Number: 41541

Part Number: D37661

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST246A

SS 08/12/11 @2

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/11 AJ

Job Completion



mf 08-12-11

D3766-1 FRONT RAIL, LH

D3766-2 FRONT RAIL, RH

D3766-3 REAR RAIL

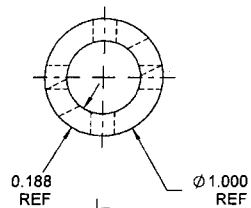
WFO 41541

08.07.10

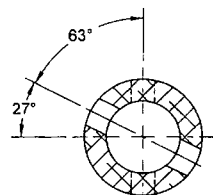
NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.000" X 0.188" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061-T6T1.000W.188)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3766-1, 1.55 lbs
D3766-2, 1.55 lbs
D3766-3, 1.55 lbs

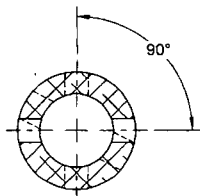
B	CHANGE HOLE SIZE TO 0.201, ADD HOLES, SHIFT HOLES FOR ATTACHING FRAME BY 0.125	HS	08.06.10
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D3766	SHEET 1 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	RAIL	NTS
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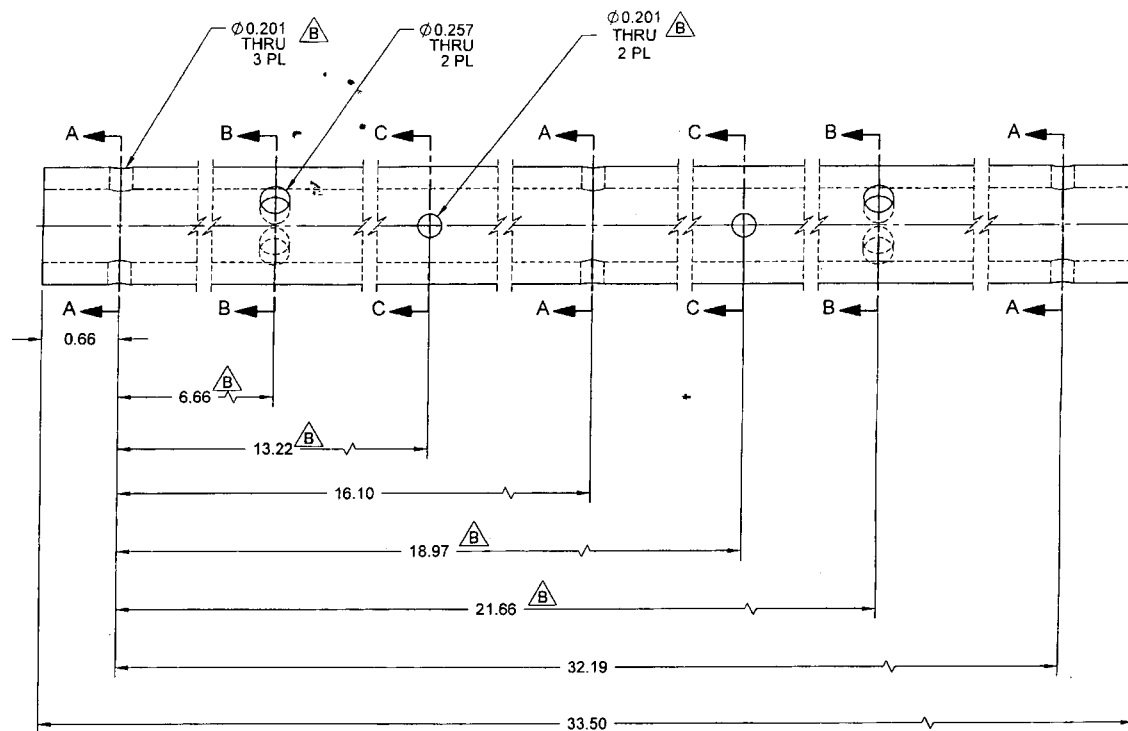
SECTION A-A



SECTION B-B






SECTION C-C

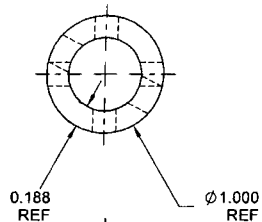


D3766-1 FRONT RAIL, LH

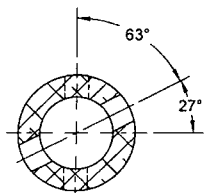
RELEASED
10/07/10

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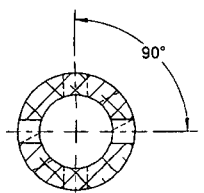
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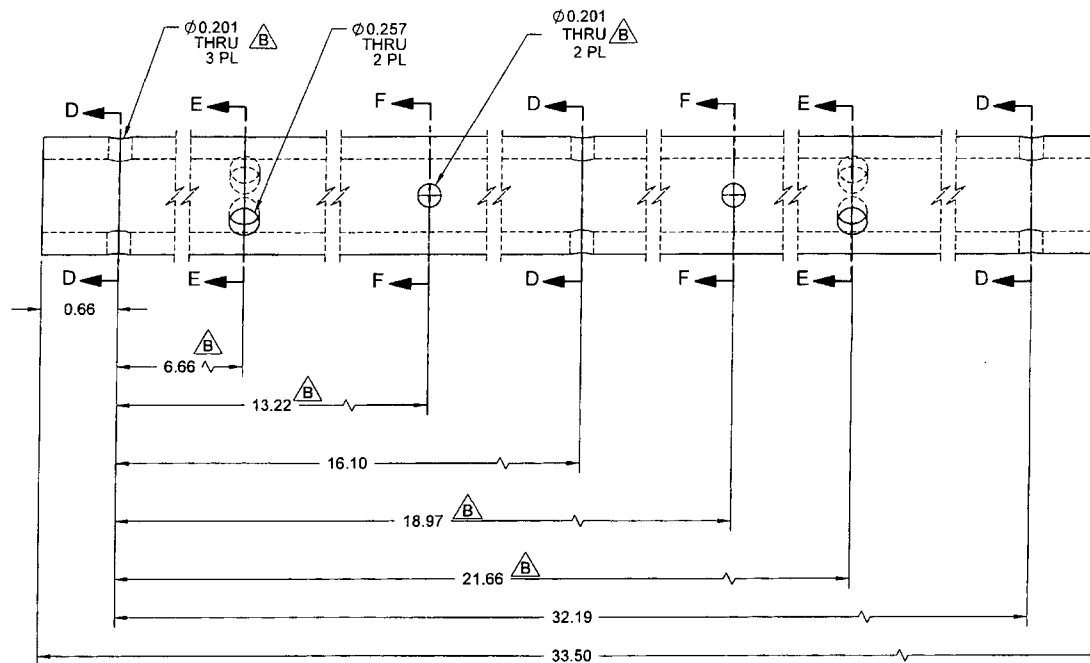
SECTION D-D



SECTION E-E



SECTION F-F



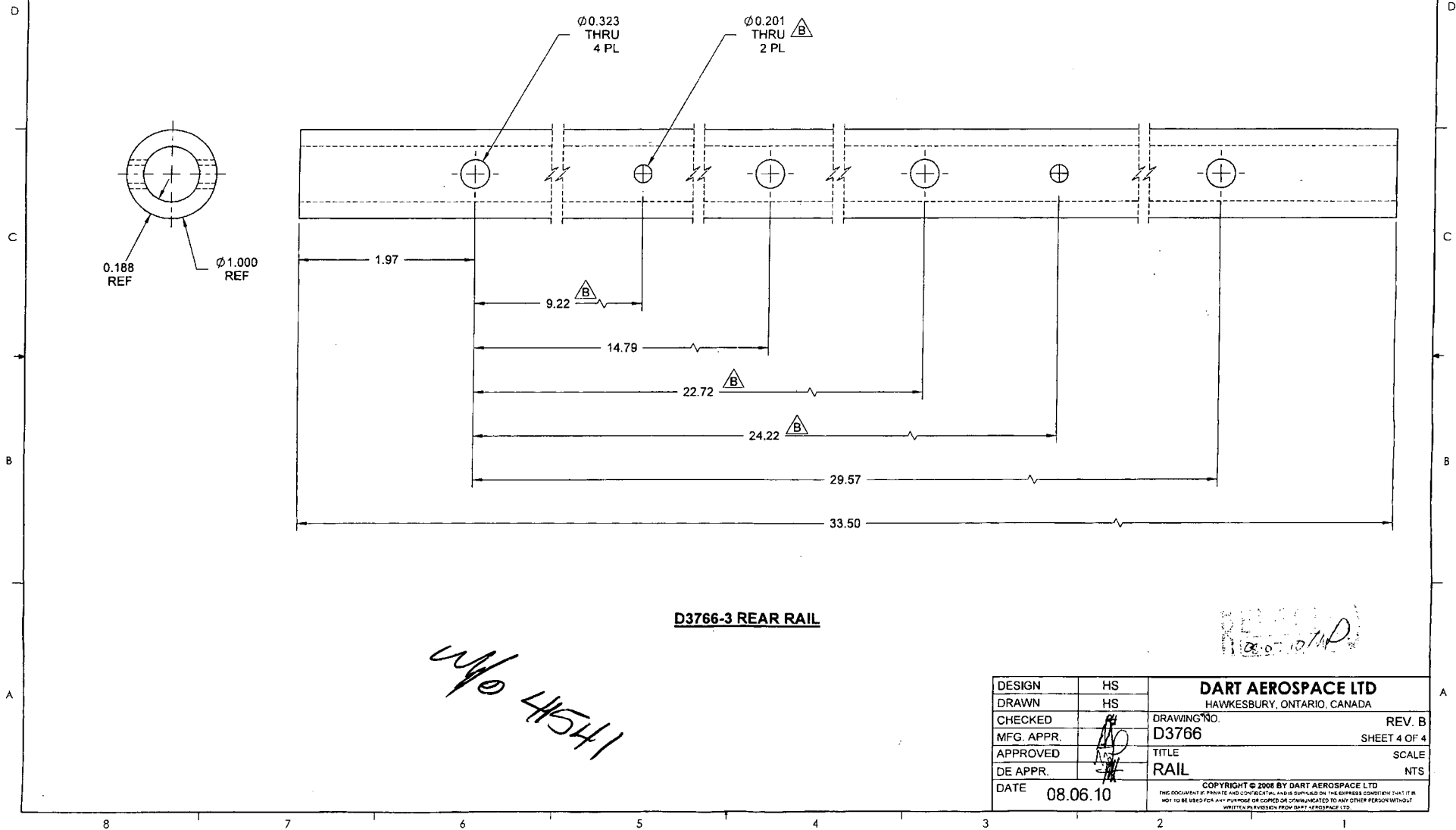
D3766-2 FRONT RAIL, RH

W6 41541




08.07.10

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8 7 6 5 4 3 2 1



D3766-3 REAR RAIL

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